



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4292-1

Job Sheet 180371



Part No: D4292-1

Job Qty: 2 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No: re-powder coat gloss black

Due Date: 7/10/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/10/18	7/10/18	0.00	0.00	Start Up Machining-2		BEB 18-07-06
140	HandFinish	2 pcs	7/10/18	7/10/18	0.00	0.11	HandFinish1		scuff
145	Powdercoat	2 pcs	7/10/18	7/10/18	0.00	0.15	Powdercoat1		re-powder coat BP 18-07-11
150	QC	2 pcs	7/10/18	7/10/18	0.00	0.00	QC3		gloss black 38
151	Small Fab	2 pcs	7/10/18	7/10/18	0.00	0.09	Small Fab-6		9-89
152	QC	2 pcs	7/10/18	7/10/18	0.00	0.00	QC5		WIA 045
180	Packaging	2 pcs	7/10/18	7/10/18	0.00	0.00	Packaging3-2		57533 6 21 9-89
190	QC21-SA	2 Ea	7/10/18	7/10/18	0.00	0.00	QC21		JUL 12 2018

Part Op 145 - MASK THREADED HOLE
Descriptions: 151 - INSTAL HELICOIL

M 138839. START: 9:05 FINISH: 9:55 A.T. 300°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4292-1	Fitting	2 Ea (1 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	2 Ea (1 ea)	151-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4292-1	2	4	0
151-Small Fab	MS21209F1-10	2	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.063Inches $\pm$ 0.010	0.073 0.053	csk	
2	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240		
3	Fitting	0.125Inches + 0.030 - 0.010	0.155 0.115		
4	Fitting	2.950Inches $\pm$ 0.030	2.980 2.920		

57533 x4

Plex 7/5/18 11:10 AM dart.lacelle.linda

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Description \ Container No: S089523 Part: D4292 - 1 Job No: 180371 Serial No/Batch: S089523 Revision: Inspector: Exp Date: Instructions: Date: 07/06/18																																																															
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